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D4634-143
Job Sheet 167077-B



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	2017-12-14
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	12/12/19
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	17/12/19
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	DEC 21 2017
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	2017-12-27
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	-D4634-3 <u>5021640</u>	1	2	0	0
	-D4636-5 <u>F164514</u>	2	43	0	0
	-D4647-1 <u>5021638</u>	1	4	0	0
	-D4664-5 <u>5021637</u>	6	39	0	0
	-D4712-1 <u>5021636</u>	2	4	0	0
	-D4732-21 <u>5021635</u>	1	6	0	0
	-D4732-25 <u>5021634</u>	1	7	0	0
	-D5021-3 <u>5021633</u>	1	2	0	0
	-MPNY-750S-9-C <u>5021632</u>	3	570	0	0
	-MS20426AD3-4 <u>5021631</u>	4	5,055	0	0
	-MS20426AD4-6 <u>5021630</u>	4	2,797	0	0
	-MS21059L08 <u>5021629</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order:		AGAINST DEPARTMENT/PROCESS			
Part No.		Skid-tube		Cross tube	
NCR No.		Machining		Small Fab	
Date :		Thermoforming		Finishing	
		Large Fab		Composite	
		Water Jet			
		Prod. Eng. Coord.			
		Rec/Store/Packaging			
		Supplier			
		Engineering			
		Quality			
		Other			
QTY Effective :				MRB (QS1042) Approval	
Disposition				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
FAULT CATEGORY					
Temperature/Cure				Power Loss/Surge	
Set-up				Folio/Program	
3OM/Route				Grain	
Broken/Damage/Defect				Weld	
Inspection Incomplete/Unqualified				Wrong Stock Pulled	
Contamination				Out of Sequence	
Countersink				Off-set	
Cut Too Short				Mislabeled	
Instructions Incomplete/Unclear				Fit/Function	
Drill Holes				Misaligned/off center	
				Positioned Wrong	
				Outside Dimensions	
				Over/Under tolerance	
				Part Incorrect	
				Part Lost/Missing	
				Part Moved	
				Drawing	
				Finish	
				Misread	
				Turning Sequence	